

Date: Friday, 13/06/2008 10:47:39 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 39861A		
Estimate Number	: 10375		
P.O. Number	:	Part Number	: D30651
This Issue	: 13/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3065 REV. B
First Issue	: / /	Project Number	: N/A
Previous Run	: 38650A	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JULIE LECOCQ</u>	Due Date	: 30/06/2008
Comment	: Est: C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est: D 06.04.25 Water jet EC	Qty:	100
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3-040 sheet
-----	-------------	-------------------



Comment: Qty.: 0.1300 sf(s)/Unit Total: 12.9990 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S-040) Batch: _____

formed @ GFI

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

PG



issue P10: 6563 GFI
cut & formal as per Dwg D3065 Rev B



100

Comment: FLOW WATER JET
 1-Cut as per Dwg D3065
 Dwg Rev: _____
 Prog Rev: _____
 2-Deburr as required

C208106113

100

3.0	QCZ	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

RG



Received + inspect for transit damage
ensure C+C attached



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

100

4.0	QCS	SECOND CHECK
-----	-----	--------------

QCS



Comment: SECOND CHECK

100

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:47:39 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 39861A

Part Number: D30651

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

Done at GF2 06/07/07

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

u/h see step #4.0 06/07/07

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-07-07

100

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/07/07

100

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pi 8/7/7 (u)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



u 8-07-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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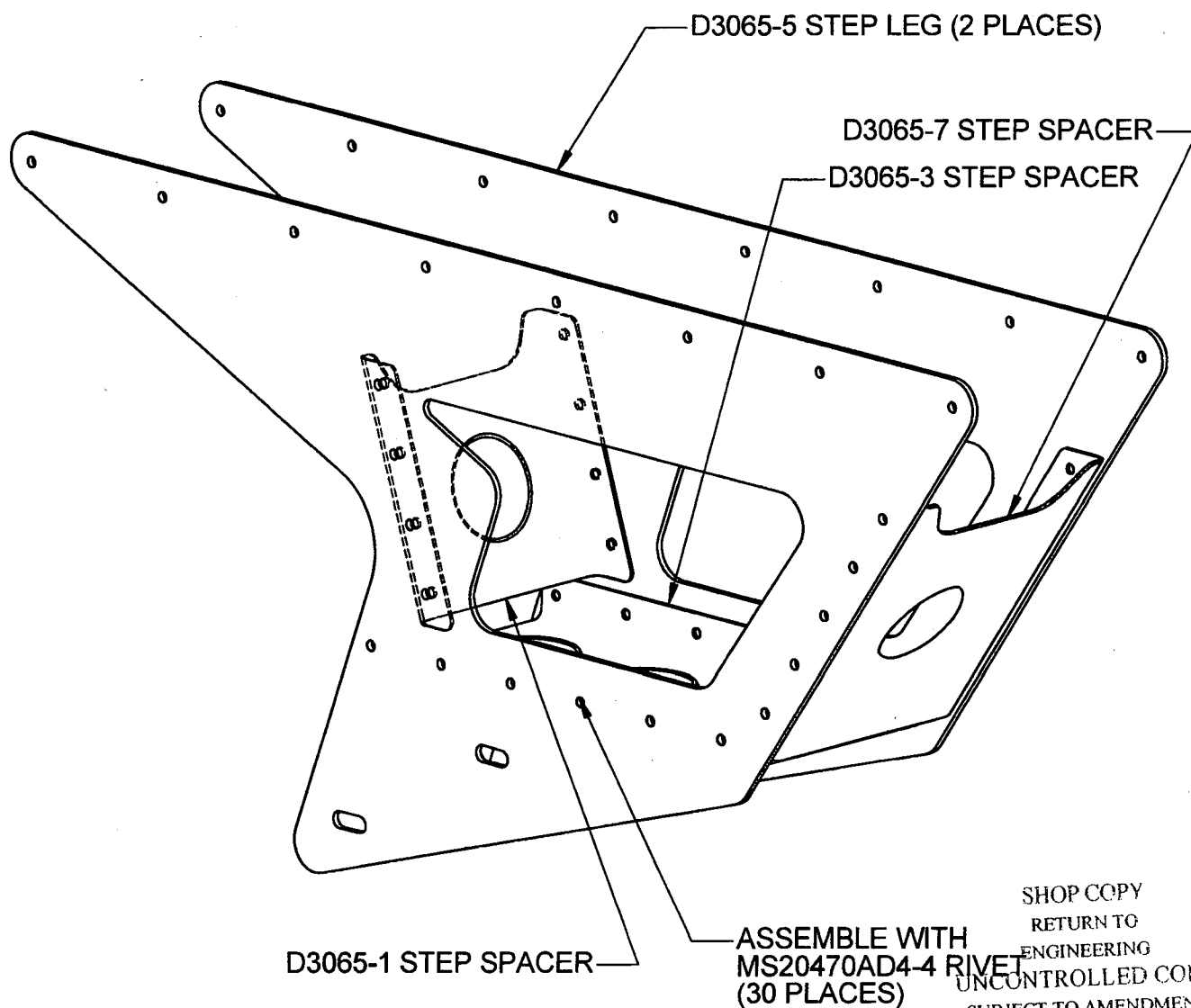
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

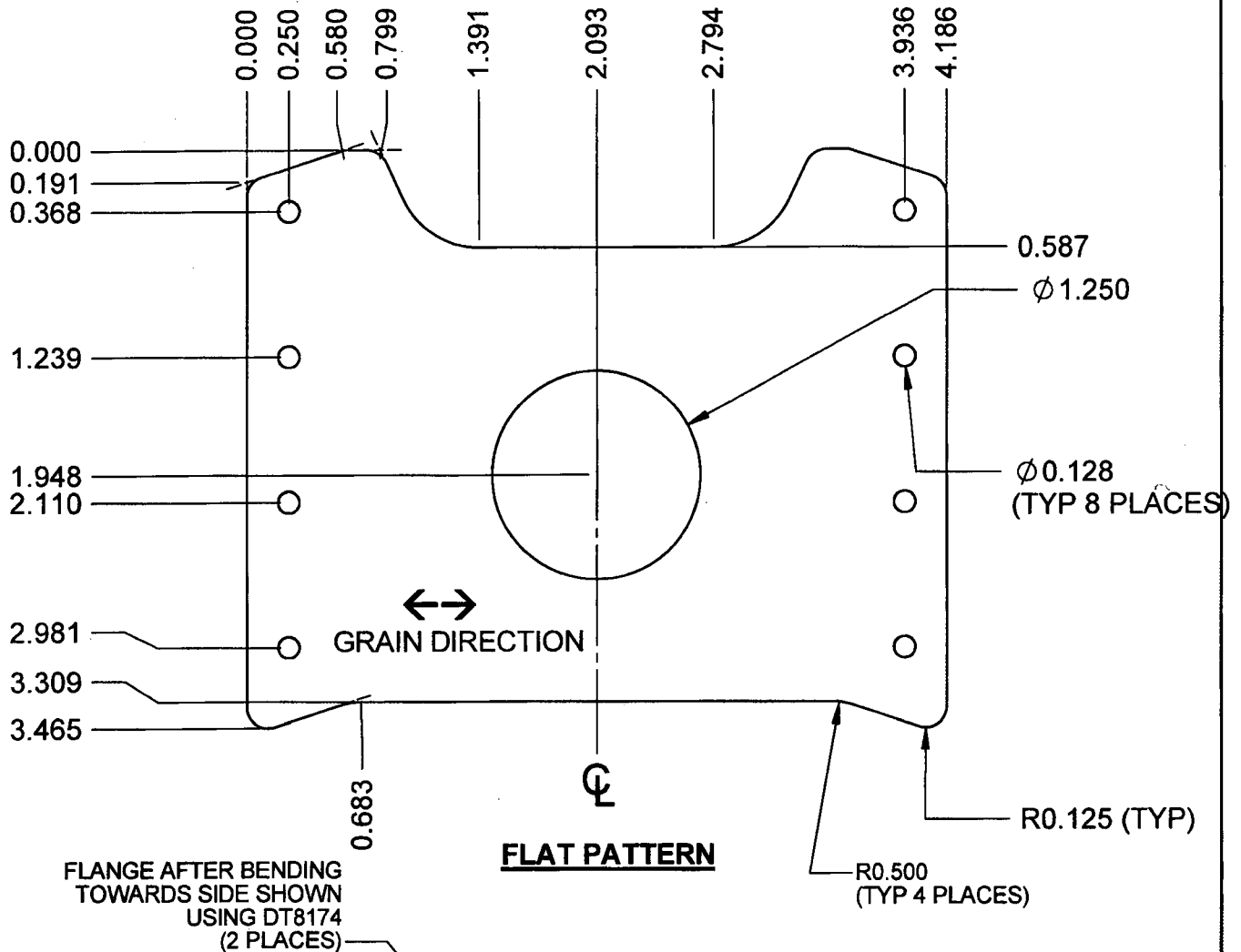
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NO. *39861A*

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

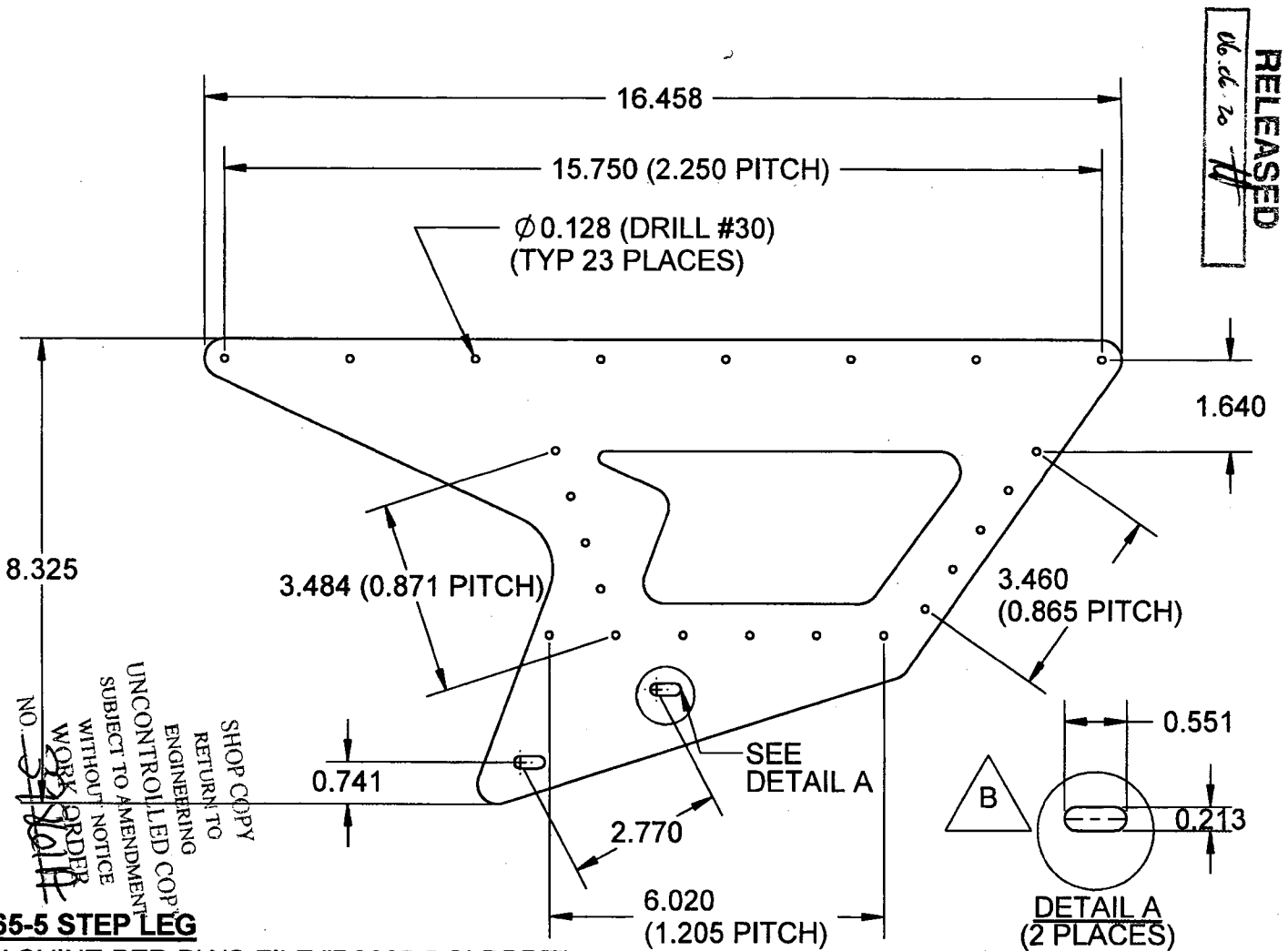
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84	11	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE 1:3



D3065-5 STEP LEG

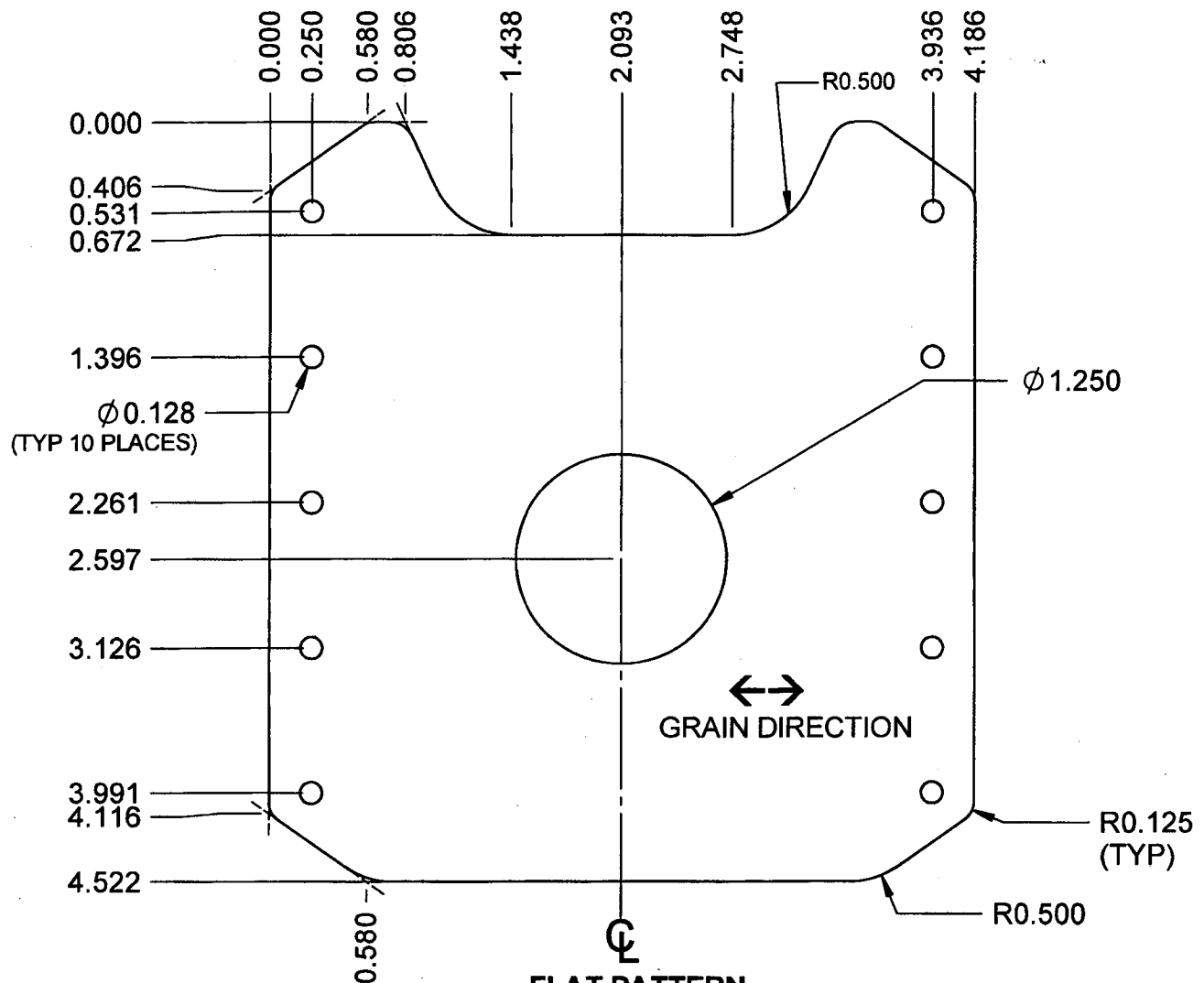
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED

de de 20

0.62

BEND DETAIL

R0.125 (TYP)

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. *39861A*



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON
SHIPPING DATE

N° BON DE LIVRAISON
SHIPPING MEMO NO.

2008/07/02

0397188

• NDU À / SOLD TO

EXPÉDIÉ À / SHIPPED TO

ART AEROSPACE LTD
270 ABERDEEN ST.
AWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J0185126	PO00006563	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
100	D30651	STEP SPACER		

5
08/02/07

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 3 OUR JOB NO J0185126 SHIPPING MEMO 0397188

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>100 PCS</u>	<u>PO00006563</u>	<u>D30651</u>	<u>B</u>	<u>STEP SPACER</u>	<u>B</u>

MATERIAL AL 2024-T3 (QQ-A-250/4) SUPPLIED BY SAMUEL / KAISER ALUMINUM MAT. REL. NO. H/N # 411944A2

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 JULY 2008

G.F.I. Q.C. REP.

B. Samiee





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ – LETTER OF COMPLIANCE

Date: 18 JUIN 2008

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 73751
Customer's order #:

de commande SSMQ: 881160
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	2	.040" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	411944A2

Bien à vous,
Yours truly,



Cherrie Pizzetti

Commis à l'administration.
Administration Clerk.

SHIP TO: SAMUEL MISSISSAUGA 2360 DIXIE ROAD MISSISSAUGA, ON, CA L4Y1Z7
SOLD TO: SAMUEL LAVAL 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM
 Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4112280

BL 101120

CUSTOMER PO NUMBER: N20349	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP RUN/LOAD ID: 101120/8	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1058202	LINE ITEM: 2	SHIP DATE: 1-NOV-2007	ALLOY: 2024	CLAD: BARE
TEMPER: T3	PRODUCT DESCRIPTION: MILL FINISH COIL			
WEIGHT SHIPPED: 4442 LB	QUANTITY: 1 PCS EST.	INL NUMBER: 2015028	GAUGE: 0.0400 IN	WIDTH: 48.000 IN
			LENGTH: 0.000 IN	

Certified Specifications

AMS 4037/RevN
 CMMP 019/RevD

AMS-QQ-A-250/4/RevA
 CMMP 025/RevR

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 411944A2 Cast 398

Drop 18

Ingot 2

08/07/07

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.1 : 68.1 (470 : 470)	46.8 : 47.0 (323 : 324)	17.9 : 18.3

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.29	4.5	0.60	1.4	0.02	0.12	0.02	0.01	0.00	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy